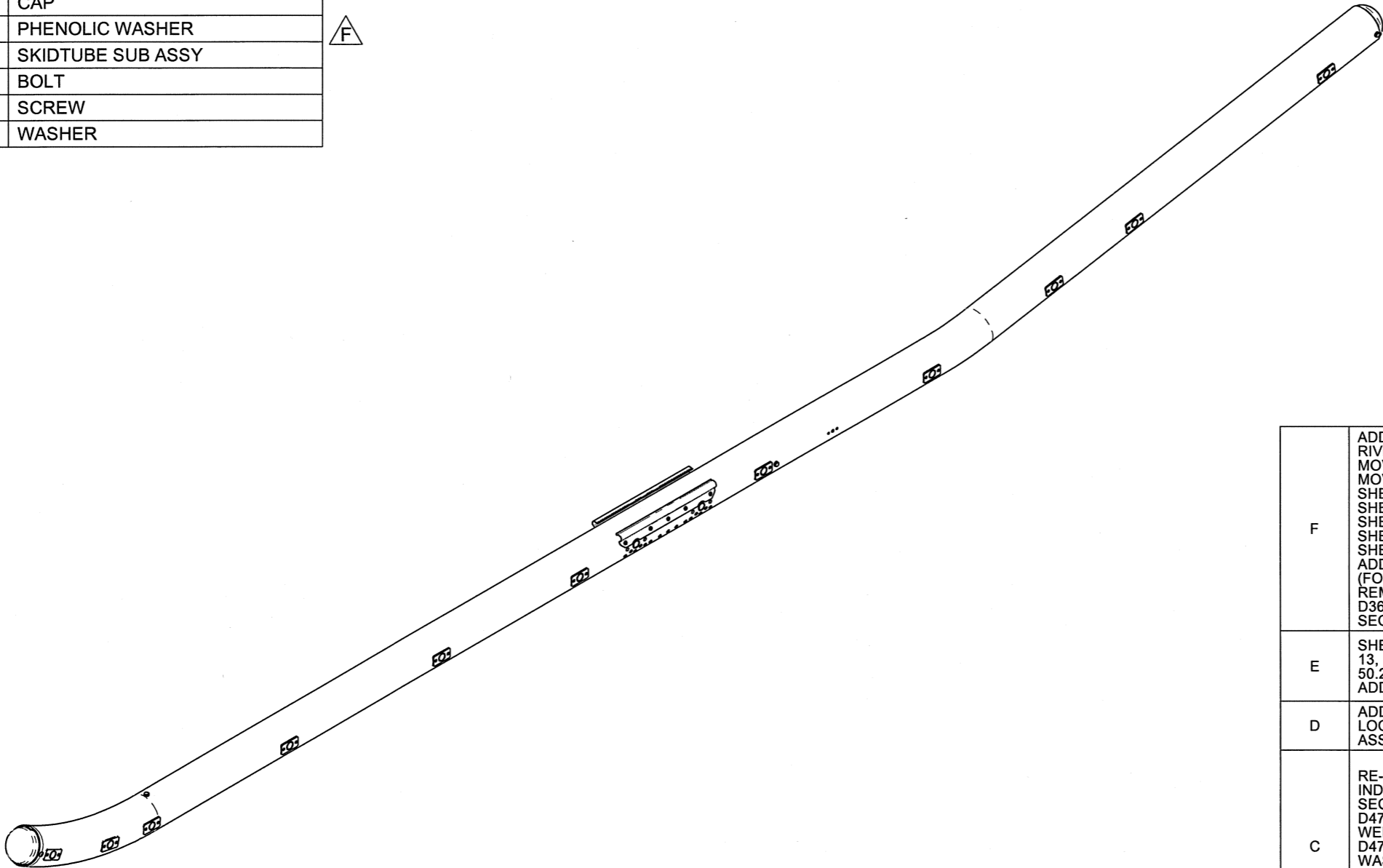


QTY -041	P/N	DESCRIPTION
X	D4766-041	SKIDTUBE
1	D2965	CAP
1	D2965-3	CAP
2	D3672-1	PHENOLIC WASHER
1	D4766-043	SKIDTUBE SUB ASSY
2	AN3C5A	BOLT
2	AN526C1032R10	SCREW
2	NAS1149C0332R	WASHER



D4766-041 SKIDTUBE

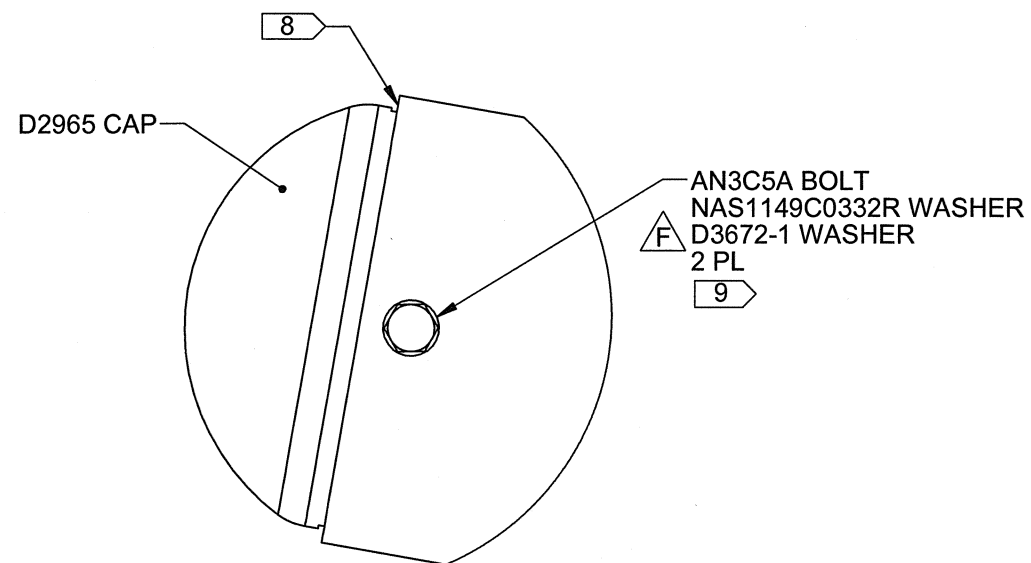
F	ADDED MS21048L4 NUTPLATES AND CR1122-3-02.5 RIVETS FOR WEARPLATES. MOVED FWD FLOAT AND WEARPLATE HOLES 0.21 AFT, MOVED AFT FLOAT HOLES 0.61 AFT SHEET 3: ADDED DETAIL Q SHEET 4: DIM 14.95 WAS 14.33, ADDED DETAIL R SHEET 5: DIM 16.0 WAS 15.8, 31.5 WAS 31.3 SHEET 6: DIM 32.6 WAS 35.9, ADDED FWD ARROW SHEET 7: DIM 97.90 WAS 98.11, HOLE QTY 8 PL WAS 7 PL, ADDED FWD ARROW. (FOR OEM FLOAT COMPATIBILITY) REMOVED ITEM NUMBERS AND BALLOONS, ADDED D3672-1 WASHER FOR AFT CAP, CHANGE NOTES FOR SECTION C-C AND G-G TO MATCH H145 SKIDTUBES	ZF	18.11.22
E	SHEET 4: ADD ITEMS 3, 4, 5 & 6. SHEET 6: ADD NOTES 9 - 13, DETAIL M, SECTION N-N, SECTION P-P & DIM 35.9 WAS 50.2. SHEET 7 Ø0.188 DIM WAS Ø0.125. WEIGHT UPDATE. ADD PROSEAL 1422. REASON: NCR 17-6303, PAR16-519	AJS	17.03.30
D	ADDED D5304-1 SWAGED CROSSBOLT SPACER FOR GHL LOCATIONS. ADDED SHT 1. REMOVED D3492-055 PLUG ASSEMBLIES, RE-ORDER SECTIONS	AP	15.11.02
C	RE-ORGANIZED SECTIONAL/DETAIL VIEWS ALL SHTS; IDENTIFICATION MOVED FROM SHT 1 TO SHT 5; SECTION D-D AND DETAIL K 11PL WAS 12PL; MODIFIED D4766-043 FINISH; Ø0.750 WAS Ø0.758 (B4-3); D5085-1 WEB WAS D4768-1; VARIOUS MINOR DIM CHANGES TO D4766-1/-045 TO MATCH STD SKIDTUBE PROFILE; 35.9 WAS 29.1 (B7-4); GROUNDING FASTENER MOVED AFT 0.25 (D5-5); D2965 HARDWARE AND GROUNDING HARDWARE CHANGED TO STAINLESS; ADD NOTE 9 (SHT 1) AFT FLOAT HOLES NOW DIMENSIONED AFTER AFT BEND	AP	15.02.25
B	FWD CAP WAS D2965 NOW D2965-3. D3492-055 WAS D3492-051. SWAGING NOW 0.650 WAS 0.661 (C7-2). ADDED BENDING DETAIL TO SHEET 4. MATERIAL D2962-190 WAS D2962-185 (A7-5). ADDED DETAIL L ON SHT 3. ADDED TOP VIEW ON SHT 5. REPLACED D4768-1 WITH D4927-041 ON SHT 3. GROUND HANDLING THRU HOLES SPACERS NOW WELDED, SEE SECTION H-H (B4-2). RE-ORDERED SECTIONS AND DETAILS.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE

DESIGN	AP	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. F
MFG. APPR.	DD	D4766	SHEET 1 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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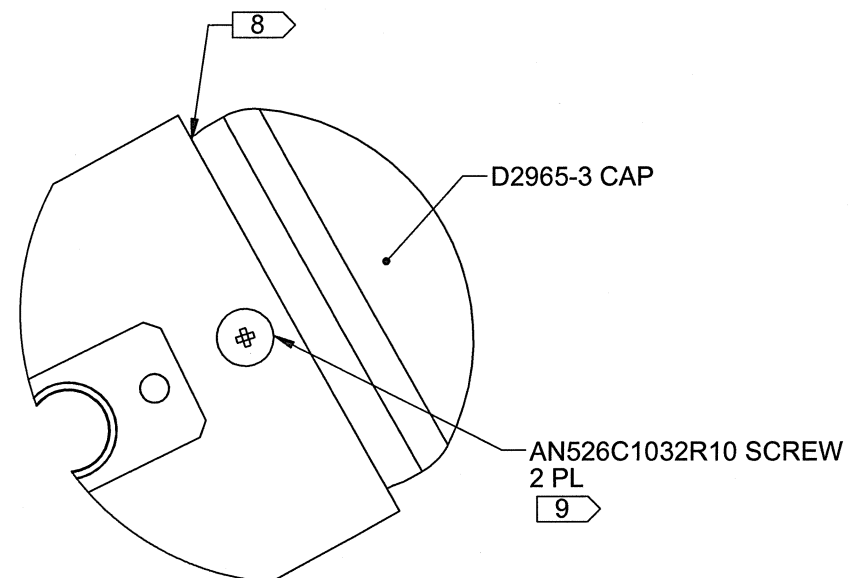
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2019 SEP 10 MD
ECN 19-890

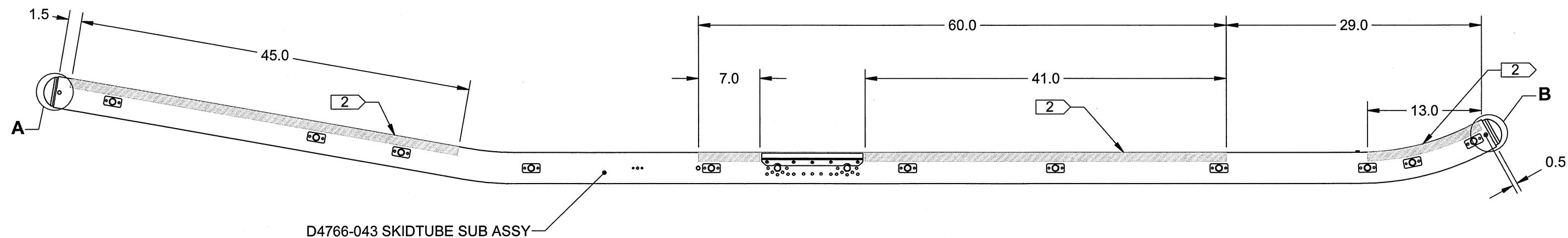
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DETAIL A
SCALE 6X



DETAIL B
SCALE 6X



D4766-041 SKIDTUBE

NOTES:

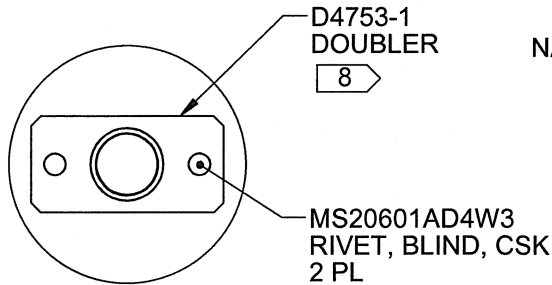
- 1) MATERIAL: N/A
- 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 35.0 lbs
- 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT

RELEASED
2019 SEP 10 NP

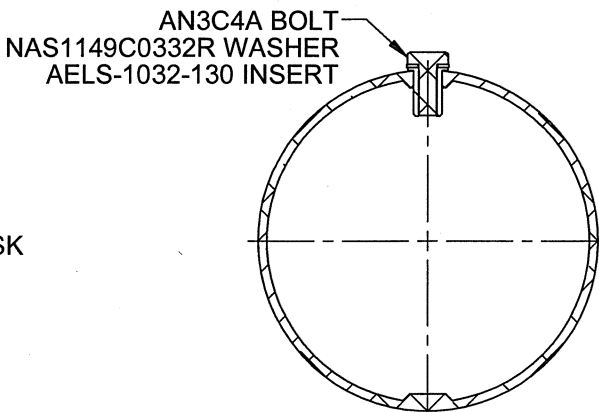
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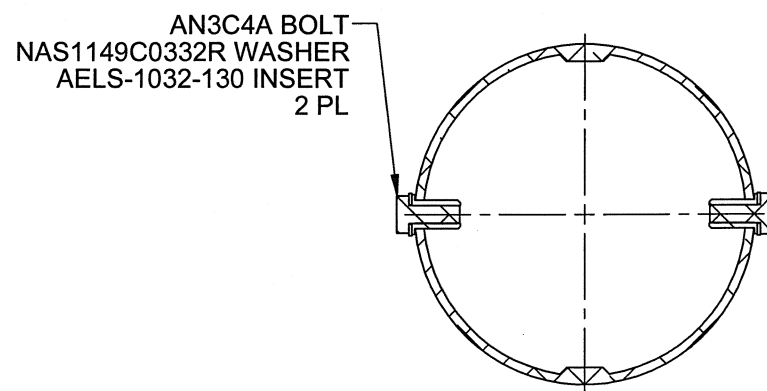
QTY -043	P/N	DESCRIPTION
X	D4766-043	SKIDTUBE SUB ASSY
11	D4686-1	SPACER
22	D4753-1	DOUBLER
1	D4766-045	SKIDTUBE SUB ASSY
2	D5304-1	CROSSBOLT SPACER
3	AELS-1032-130	INSERT
3	AN3C4A	BOLT
4	CR1122-3-02.5	RIVET
44	MS20601AD4W3	RIVET, BLIND, CSK
2	MS21048L4	NUTPLATE
3	NAS1149C0332R	WASHER



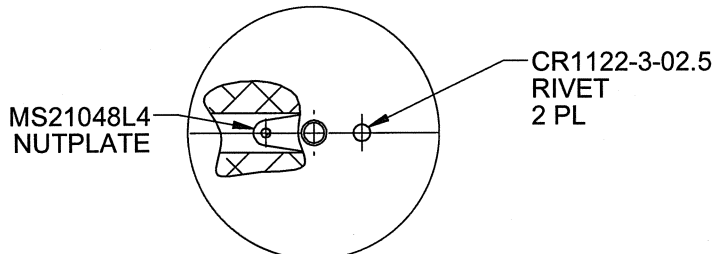
DETAIL E
SCALE 6X
22 PL



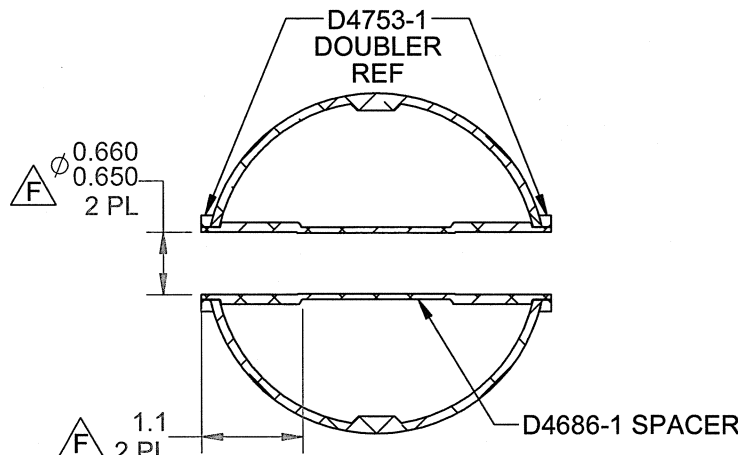
SECTION D-D
SCALE 6X



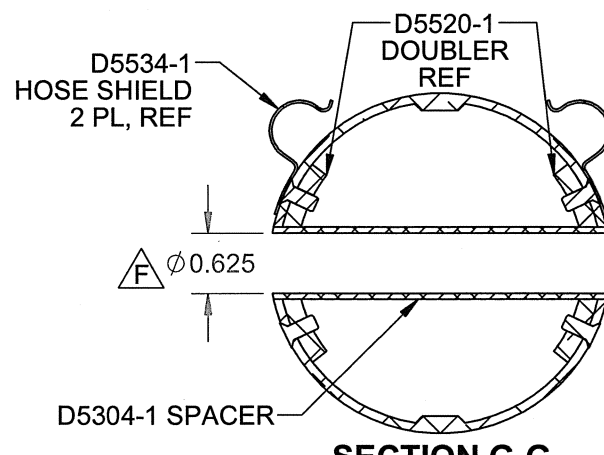
SECTION F-F
SCALE 6X



DETAIL Q
SCALE 6X
BOTH SIDES



SECTION C-C
SCALE 6X
11 PL



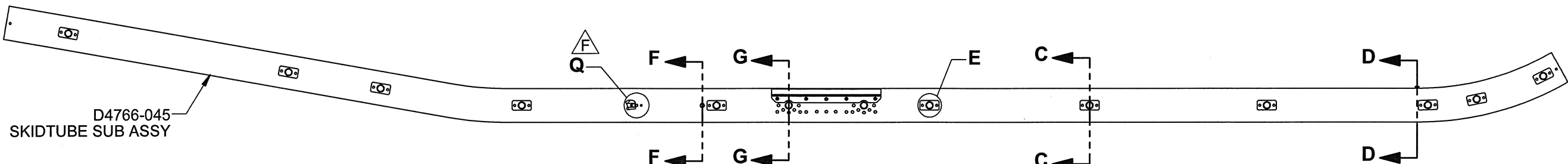
SECTION G-G
SCALE 6X
2 PL

INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS AS FOLLOWS:

1. REAM $\phi 0.758$ THRU DOUBLERS AND SKIDTUBE.
2. INSERT D4686-1 SPACER
3. SWAGE TO $\phi 0.660 / 0.650 \times 1.0$ DP EACH SIDE PER DART QSI 002
4. TRIM/GRIND SPACER FLUSH WITH DOUBLER PER QSI 002

INSTALL D5304-1 CROSSBOLT SPACER AFTER INSTALLING D5520-1 DOUBLERS AS FOLLOWS:

1. OPEN PILOT HOLES THRU SKIDTUBE AND DOUBLERS TO $\phi 0.758$
2. INSERT D5304-1 CROSSBOLT SPACER
3. SWAGE TO $\phi 0.570 / 0.565 \times 1.0$ DP EACH SIDE PER DART QSI 002
4. OPEN HOLE THRU SPACER TO $\phi 0.625$



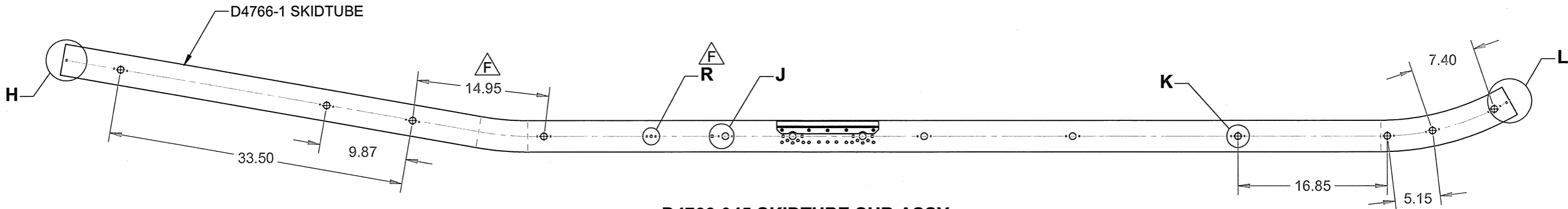
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 33.9 lbs
 - 8) SEAL FAYING SURFACES USING PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT

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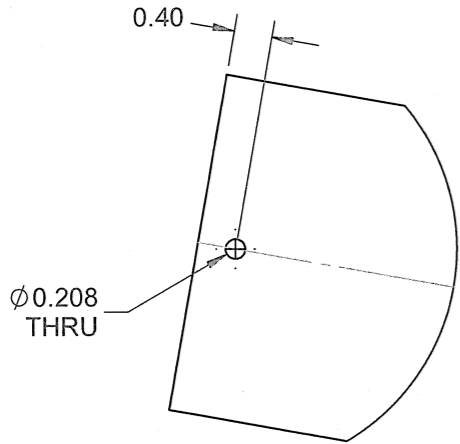
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DESIGN	AP	DART AEROSPACE USA, INC.	
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CHECKED	MW	DRAWING NO.	REV. F
MFG. APPR.	DD	D4766	SHEET 3 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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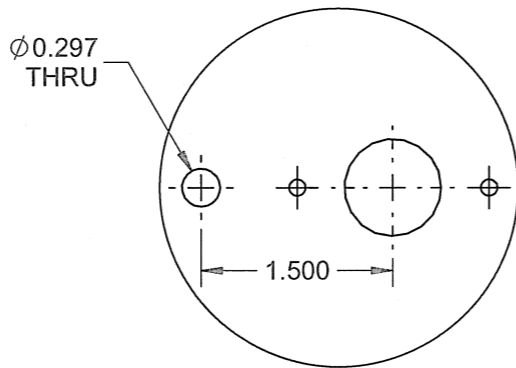
QTY -045	P/N	DESCRIPTION
X	D4766-045	SKIDTUBE SUB ASSY
1	D4766-1	SKIDTUBE
1	D5085-1	WEB
2	D5520-1	DOUBLER
2	D5534-1	HOSE SHIELD
58	CR3212-5-05	CSK RIVET, CHERRY MAX
10	CR3213-5-06	RIVET, CHERRY MAX



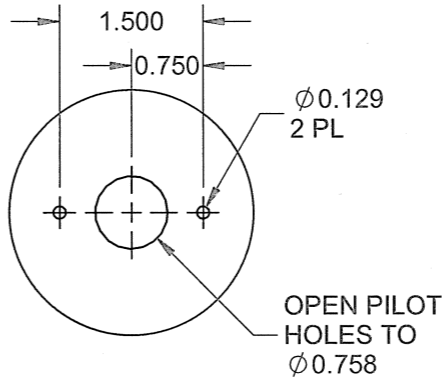
D4766-045 SKIDTUBE SUB ASSY



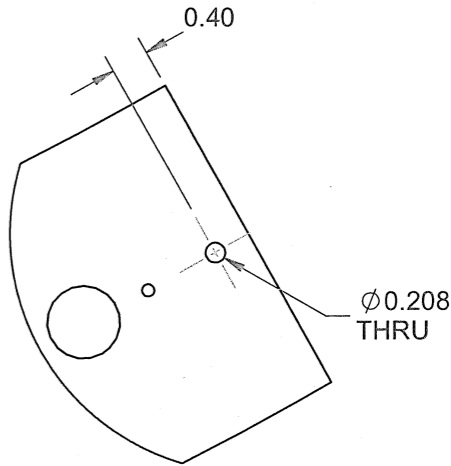
DETAIL H
SCALE 6X



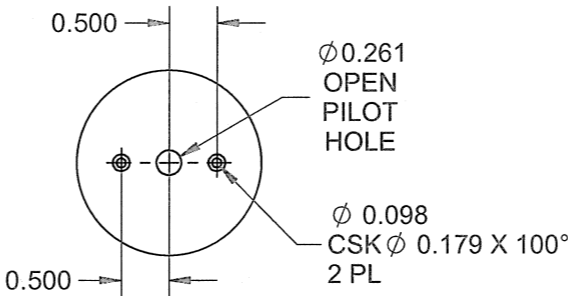
DETAIL J
SCALE 4X



DETAIL K
11 PL (BOTH SIDES)
SCALE 6X



DETAIL L
SCALE 6X



DETAIL R
SCALE 6X
BOTH SIDES

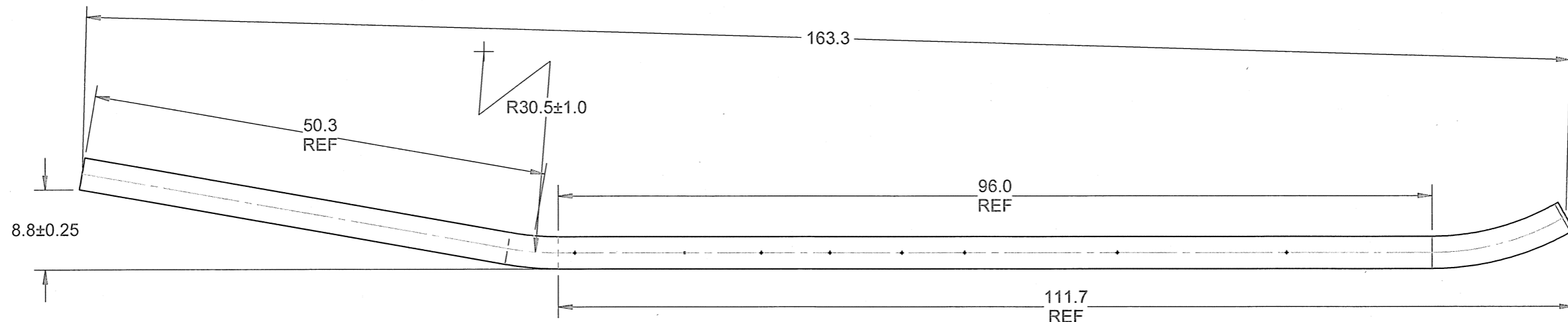
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 33.1 lbs

RELEASED

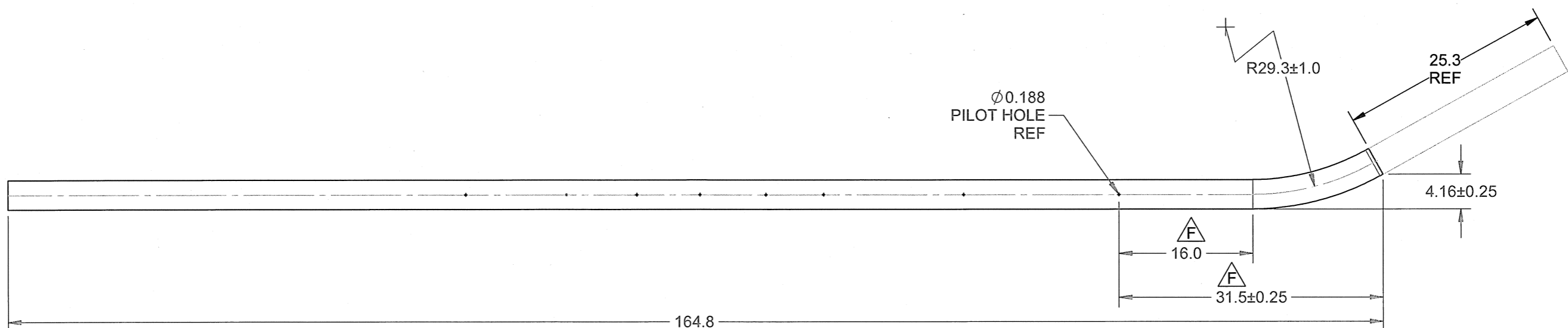
2019 SEP 10 MD

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D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, AFT BEND)



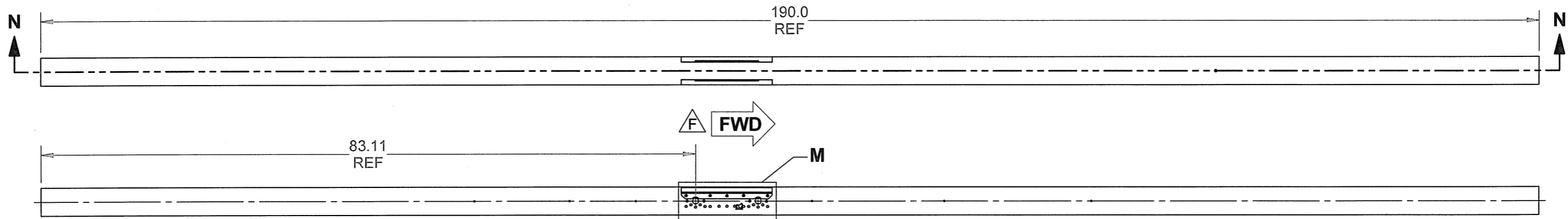
D4766-045 SKIDTUBE SUB ASSY
(BENDING DETAIL, FWD BEND)

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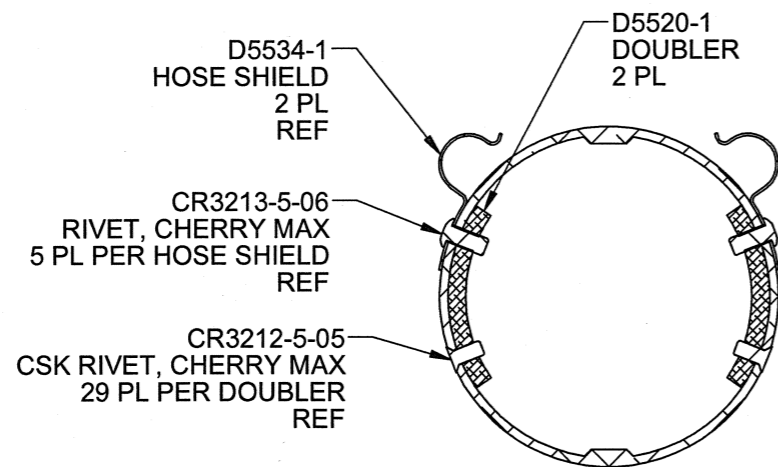
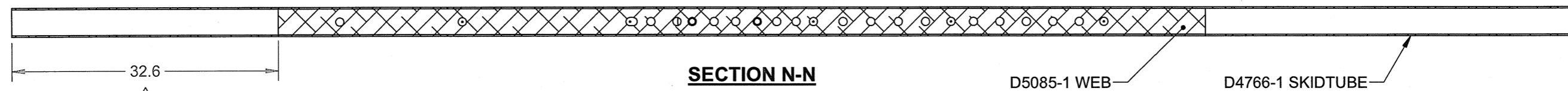
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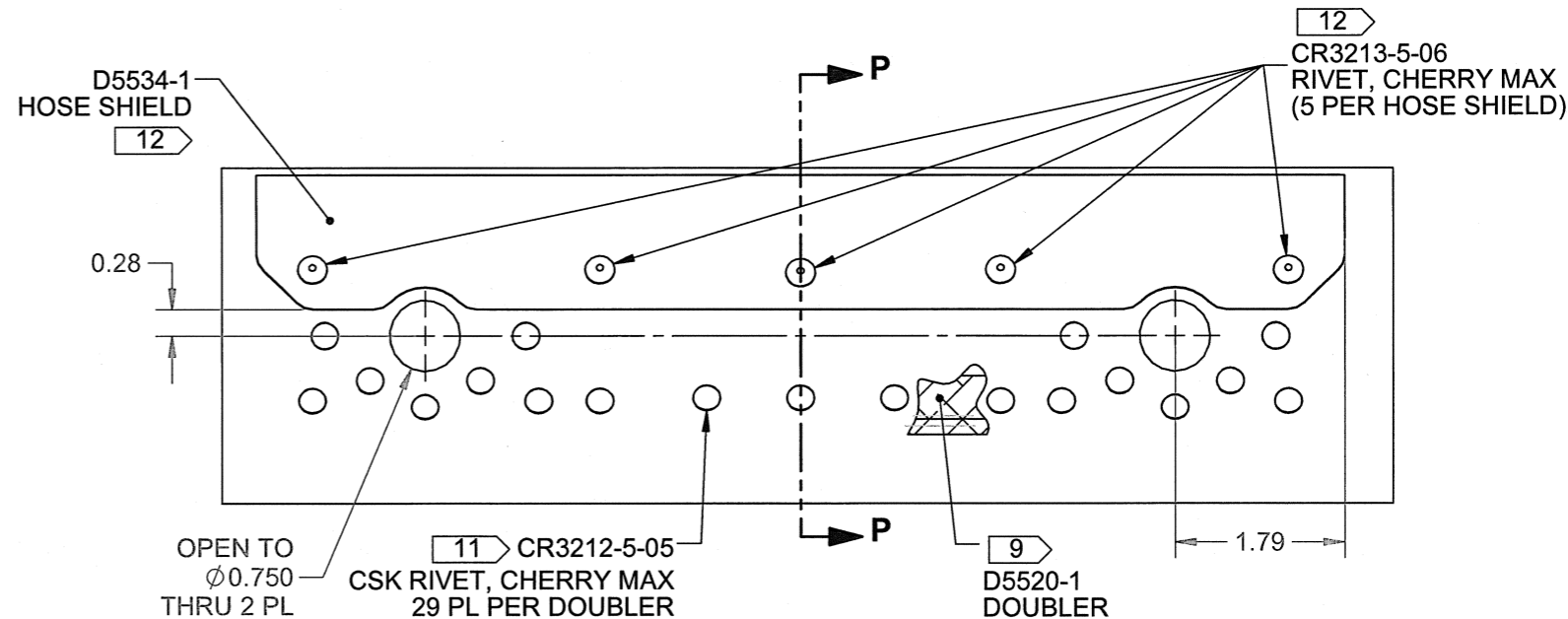
8 7 6 5 4 3 2 1



8 **D4766-045 SKIDTUBE SUB ASSY**
(ASSEMBLY DETAIL)



SECTION P-P




NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) INSERT D5085-1 WEB INTO D4766-1 EXTRUSION IN LOCATION SHOWN AND BOND INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.
- 9) LOCATE THE D5520-1 DOUBLER USING THE Ø0.188 PILOT HOLES ON THE SKIDTUBE AND DOUBLER.
- 10) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT 10309
- 11) COUNTERSINK THE SKIDTUBE Ø0.286 X 100° (29 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (29) CR3212-5-05 CSK RIVETS
- 12) FOR INSTALLATION OF THE D5534-1 HOSE SHIELD:
 - INSTALL ON FINISHED (PAINTED) SKIDTUBES ONLY
 - COAT THE FAYING SURFACES WITH PROSEAL 890/1422.
 - INSTALL THE QTY (5) CR3213-5-06 RIVETS WET USING PROSEAL 890/1422

RELEASED
2019 SEP 10 *Wp*

DETAIL M
SCALE 7X

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APPROVED	NO	TITLE	SCALE
DE APPR.	DS	 SKIDTUBE	NTS
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